

Date: Tuesday, 11/21/2006 11:28:36 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 CARGO MIRROR  
 Job Number : 29561  
 Estimate Number : 10095  
 P.O. Number : N/A Part Number : D044715011  
 This Issue : 11/21/2006 S.O. No. : N/A Drawing Number : D3243REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 29416 Material : Manufacture in multiples of 10  
 Due Date : 1/23/2007 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A 04.02.18 New issue KJ/JLM  
 Est Rev:B 06-04-28 Manufactured on Water Jet JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



(10)

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011 CHG001

KJ 06 11 29

2.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.5359 sf(s)/Unit Total : 5.3592 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: M18556 ml 06 11 29

(10)

3.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: A ml 06 11 29

Prog Rev: A

(10)

2-Deburr if necessary

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



(10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 06/11/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/21/2006 11:28:36 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 29561

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAN 06:11:30

(10)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

JB 06/12/06

(10)

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

MA 06/12/07

(10)

9.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 FE-032EF

Insert

M100895

1 D3243-1(Ref)

Bracket

B39561

SAN 07:07:05

(10)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

SAN 09:01:05

(9)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 07/01/05

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

JD 06-12-20

(10)

13.0

POWDER COATING

POWDER COATING

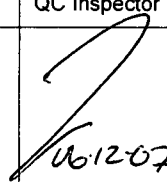



Comment: POWDER COATING

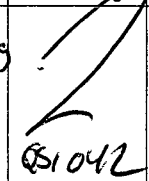

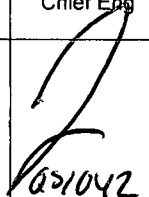
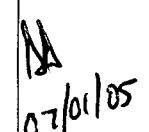
1-Powder Coat Black Sandtex (Ref. 4.3.5.7) as per QSI 005 4.3

FL/a.m 07/01/03

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/12/07	9-7/12	change made on w/o 25416					 06/12/07

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 07/01/08  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/05	12.0	Damage part when putting insert. Was not using the right tool	 05/10/05	Scrap (4) FE-032EF insert and (1) 03243-1 Bracket	SAB 07/01/05	 07/01/05	 05/10/05	 07/01/05

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:28:36 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 29561

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/21/05 (9)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D1048 Clamp B24978 1K B 27091 17X

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D1049 Saddle B24980 2X B27023

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 1 D2010-104 Arm B27229 4X B29419 S

19.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 1 D2011-101 Mirror B27143

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 ALS4-1032-130 Insert M103475

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:28:36 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 29561

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN3-4A

Bolt

M3459

1X

M14915 8X

M102832

12X

M47855X

M8912 10X

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN526C1032R10

Screw

M15672

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN960JD10L

Washer

M101291

PC 7/01/05 (9)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LB 07/01/05 (9)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location:

RVA

07/01/05 (9)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/05 (9)

Job Completion



U 07.01.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

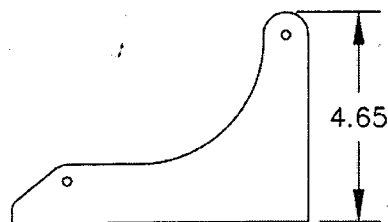
NOTE: Date & initial all entries







DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09	TITLE BRACKET		SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/  
D3243-041 ASSEMBLY  
SCALE 1:4

INSTALL  
FE-032-EF INSERTS  
(4 PLACES)

2.75  $\pm 0.030$   
0.000

8.581

8.206

7.706

11.920

11.420

Ø0.201  
(TYP 4  
PLACES)

Ø0.290  
(TYP 4  
PLACES)

1.375

5.273

3.714

0.500

0.000

RELEASED  
04.02.03

GRAIN  
DIRECTION

4.214  
R0.25 (TYP)

3.339

R0.38  
(TYP)

5.494

R2.75  
(TYP)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29561

D3243-1  
FLAT PATTERN

R0.50  
(TYP)

**D3243-041 BRACKET ASSEMBLY  
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK  
(QQ-A-250/11, REF DART SPEC  
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO  
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

6.560

5.810

5.360

0.750

0.500


0.000

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date: Thursday, 11/01/2007 2:52:48 PM  
User: Linda Lacelle

**Process Sheet**

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D044-715/D022-716 - ECN 900
Job Number	: 30248		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 11/01/2007 S.O. No. : N/A	Drawing Number	: UPDATE PAPERWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 30247	Material	: N/A
Written By	: 	Due Date	: 18/01/2007 Qty: 1 Um: Each
Checked & Approved By	: _____		
Comment	: _____		

**Additional Product**

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK  
EASA STC EASA IM.R.S.01253  
EASE STC EASA IM.R.S.01254

D044-715-011 B26137 1X B27068 10 B29561 4 (20)

D022-716-011 B21220 9X  07/01/15 7/01/12

2.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



 07.01.15